

Work Order ID 153513

Monday, November 21, 2016 9:23:52 AM

153513

Page 1

Item ID: D3283-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 11/16/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/21/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: NOV 21 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3283

Rev E

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.10

FLOW CNC Waterjet

1-Cut as per Dwg D3283

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

If using the deburring machine, ensure that parts are fed lengthwise (along length of part)

(10)

Dec 16/11/30

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.02

Quality Control

(10)

Dec 16/11/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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N900040100

Setup Start *NS1*

Stop ***NS2***

10

Start Date: 11/16/2016 **Start Qty:** 10.00

Required Date: 11/21/2016 **Req'd Qty:** 10.00**Customer:**

10

Run Start *NR1*

Stop ***NR2***

120 QC8- Inspect parts - second check

0.00

120

0.03

QC

Quality Control

Memo

DAS
38
DEC 05 2016

150 Chemical Conversion Coat per QSI005 4.1

0.00

150

0.03

HandFinish

Hand Finishing

Memo

X10 ~~0~~ 2016/12/10
BEB

160 QC7-Inspect Chemical Conversion Coat

0.00

160

0.02

QC

Quality Control

Memo

10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
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Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
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LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00				DAS 6 9-88			
170									
Packaging	Memo	0.02							
Packaging	LOCATION : LG001								DEC 08 2016
180	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-88			
180									DEC 12 2016
QC	Memo	0.17							
Quality Control									

mf
16-12-09

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Work Order update only ☐

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Picklist Print

Monday, November 21, 2016 9:23:52 AM

Page 1
1

Work Order ID: 153513

153513

Parent Item: D3283-1

D3283-1

Parent Item Name: Doubler

Start Date: 11/16/2016

Required Date: 11/21/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.09.28New issueKJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM
IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063		Purchased		No		100	sf	169.7300	0.2361	2.485263			
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M6061T6S 063

6061-T6 .063 Sheet

OK 11/11/30

Location

Loc Qty

Loc Code

MAT021

169.73

M133511

2.6

M134377

3.3

M134838

163.83

2.4

DQA: _____ Date: _____



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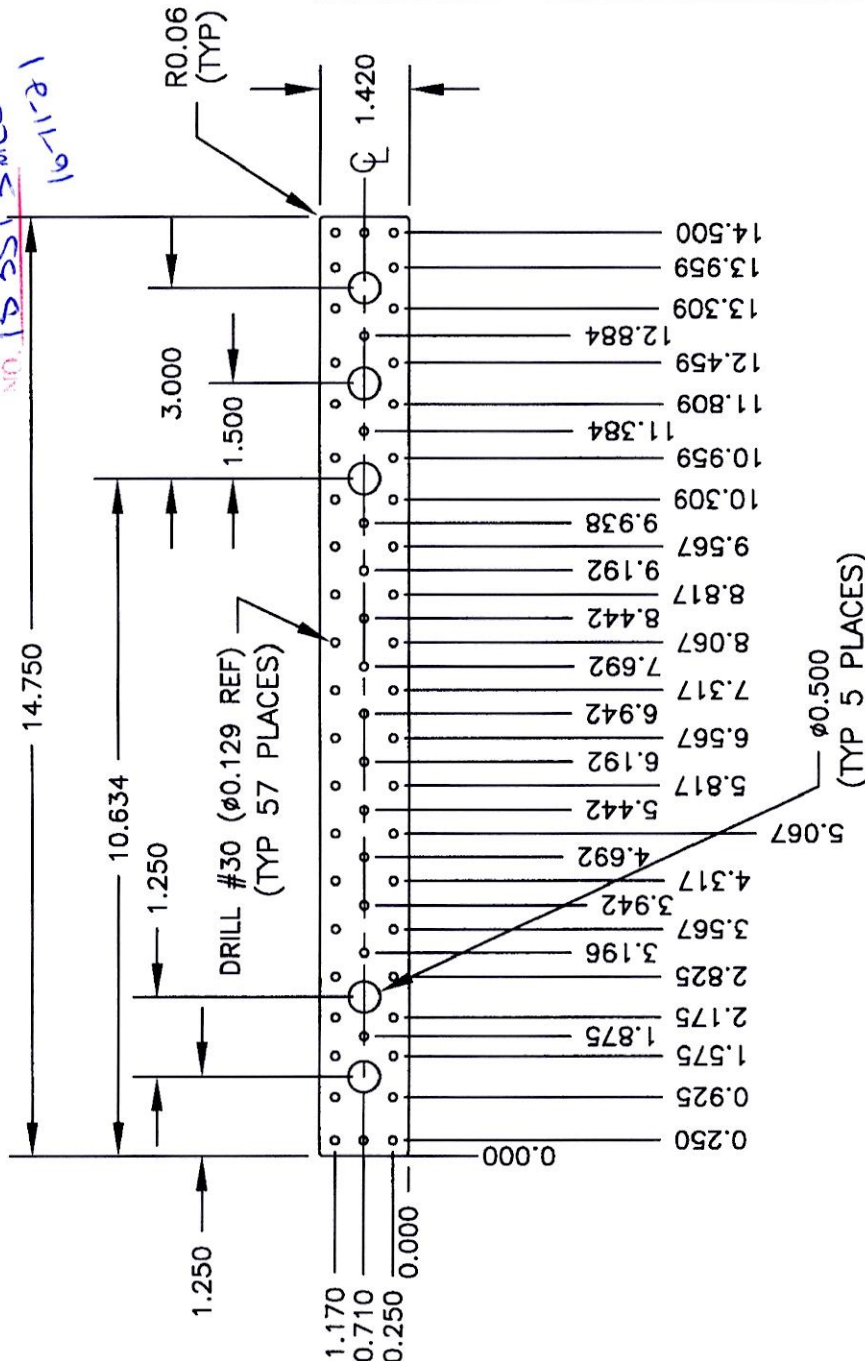
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WORK ORDER
NO. 153513 M.C.S.

10-11-21



DESIGN 99	DRAWN BY DC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED B	APPROVED H	DRAWING NO. D3283	REV. E SHEET 1 OF 2
DATE 07.06.01	TITLE DOUBLER	SCALE 1:3	
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	

D3283-1 DOUBLER

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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